

Date: Thursday, 6/29/2006 8:27:58 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	SADDLE FITTING, FWD (OUTBOARD/INBOARD)			
Job Number	27762	Part Number	D2572			
Estimate Number	10531	Drawing Number	D2572 REV E			
P.O. Number	N/A	Project Number	N/A			
This Issue	6/29/2006	S.O. No.	N/A			
Prsht Rev.	NC	Drawing Revision	E			
First Issue	N/A	Material	N/A			
Previous Run	27057	Due Date	7/15/2006	Qty:	16	
Written By	16/06/29					Um: Each
Checked & Approved By						
Comment	Est: 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D6101005	7075-T7351 8.25X5.0X2.5
Comment: Qty.: 1.0000 Each(s)/Unit Total : 16.0000 Each(s) 7075-T7351 8.25X5.0X2.5 Make from D6101-005 billet for D2572 Ensure that grain is along 5.00" length Batch No:		
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No. B22762 Double check by:		
1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges. 		
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2571 & D2572 		

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR: 27762		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06/07/09	# 2.3	One LD part scrap. "X" origin on fourth axis (3rd axis) off by .100" First Run.	BB QSI 642	Scrap / destroy and Replace Reset origin to correct value.	EP 06/07/09	✓ 06/07/10	BB 06/07/10	✓ 06/07/10
06/07/10	2.7	Saddle-to-Skidtube holes offset to one side 0.560 dimension is 0.484	QP 06.07.10 per QSI 642	SCRAP → <u>destroy</u> Ref DS email attached REPLACE	EP 06/07/14	✓ 06/07/13	QP 06.07.10 per QSI 642	✓ 06/07/13

Part No: D2572 PAR #: N/A Fault Category: Proc - CNC NCR: Yes No DQA: AB Date: 06.07.20
 NOTE: Date & initial all entries

QA: N/C Closed: AB

Date: 06.07.21

Date: Thursday, 6/29/2006 8:27:59 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 27762

Part Number: D2572

Job Number:



Seq. #: Machine Or Operation:

Description :

4.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SG/EP 06/07/18 N16

5.0 QC8

SECOND CHECK



Comment: SECOND CHECK

SD 06.07.18 X16

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

SAP 06.07.18 X16

7.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

SC 06/07/19 (16)

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

Q.M 06-07-18

(16)

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: SDY79

10.0 6/7/20 (16)

(16)

10.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

10.0 6/7/20 (16)

(16) 06/12/04

Job Completion



U 06/07/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD				Work Order: 27762	
Description: Saddle, Fwd Inboard				Part Number: D2572	
Inspection Dwg: D2572 Rev. E				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	0.441	0.441	0.441	0.441		
B	1.745	1.755		1.747	1.747	1.746	1.747		
C	3.495	3.505		3.497	3.498	3.497	3.497		
D	1.745	1.755		1.747	1.747	1.746	1.747		
E	7.990	8.010		8.000	8.000	8.001	8.000		
F	0.490	0.510		0.492	0.493	0.494	0.493		
G	0.257	0.262	DT8683	0.259	0.257	0.257	0.257		
H	0.375	0.380	DT8684	0.374	0.377	0.377	0.377		
I	0.490	0.510		0.492	0.494	0.495	0.496		
J	1.174	1.184		1.178	1.178	1.178	1.179		
K	0.558	0.578		0.560	0.561	0.563	0.563		
L	1.174	1.184		1.178	1.178	1.179	1.180		
M	1.490	1.500		1.493	1.494	1.495	1.497		
N	2.495	2.505		2.499	2.498	2.497	2.498		
O	3.869	3.879		3.870	3.871	3.872	3.874		
P	0.115	0.135		0.124	0.125	0.124	0.125		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.253	0.254	0.254	0.252		
S	0.115	0.135		0.126	0.124	0.119	0.120		
T	0.178	0.198		0.182	0.182	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.238	0.237	0.238	0.237		
W	0.115	0.135		0.125	0.124	0.123	0.124		
X	0.307	0.312		0.310	0.310	0.316	0.310		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.358	0.359	0.361	0.364		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.619	0.680	0.621	0.684		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.244	0.244	0.244	0.241		
AE	1.375	1.395		1.385	1.384	1.385	1.384		
AF	0.115	0.135		0.135	0.131	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.248	0.247	0.248	0.247		
AI	2.000	2.020		W19	W19	W14	W14		
AJ	0.023	0.043		0.030	0.030	0.031	0.030		
Accept/Reject									

Measured by:	SD / S.G	Audited by:	SD
Date:	06.07.10	Date:	06.07.13

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	SJL

DART AEROSPACE LTD				Work Order: 27762	
Description: Saddle, Fwd Inboard				Part Number: D2572	
Inspection Dwg: D2572 Rev. E				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	0.440	0.440	0.440	0.440		
B	1.745	1.755		1.749	1.748	1.747	1.745		
C	3.495	3.505		3.501	3.499	3.497	3.499		
D	1.745	1.755		1.748	1.747	1.746	1.745		
E	7.990	8.010		8.001	8.001	8.006	8.000		
F	0.490	0.510		0.501	0.501	0.500	0.492		
G	0.257	0.262	DT8683	0.258	0.258	0.258	0.258		
H	0.375	0.380	DT8684	0.376	0.376	0.376	0.376		
I	0.490	0.510		0.500	0.501	0.500	0.494		
J	1.174	1.184		1.180	1.180	1.179	1.175		
K	0.558	0.578		0.568	0.568	0.567	0.561		
L	1.174	1.184		1.179	1.179	1.178	1.175		
M	1.490	1.500		1.497	1.498	1.496	1.492		
N	2.495	2.505		2.499	2.501	2.500	2.498		
O	3.869	3.879		3.874	3.873	3.874	3.872		
P	0.115	0.135		0.130	0.128	0.127	0.126		
Q	0.115	0.135		0.128	0.126	0.121	0.125		
R	0.240	0.260		0.251	0.252	0.251	0.252		
S	0.115	0.135		0.125	0.124	0.122	0.123		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.961	2.960	2.961	2.960		
V	0.230	0.250		0.240	0.241	0.240	0.237		
W	0.115	0.135		0.130	0.128	0.127	0.126		
X	0.307	0.312		0.309	0.310	0.309	0.310		
Y	0.760	0.765		0.761	0.761	0.761	0.761		
Z	0.352	0.372		0.364	0.364	0.365	0.367		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.630	0.629	0.626	0.622		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.244	0.244	0.244	0.246		
AE	1.375	1.395		1.388	1.389	1.387	1.386		
AF	0.115	0.135		0.134	0.135	0.135	0.135		
AG	0.240	0.280		0.240	0.241	0.240	0.260		
AH	0.240	0.260		0.250	0.252	0.253	0.247		
AI	2.000	2.020		N/A	N/A	N/A	N/A		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	5.G / Ep	Audited by:	SD
Date:	06.07.13	Date:	06.07.13

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	SD

DART AEROSPACE LTD				Work Order: 27762	
Description: Saddle, Fwd Inboard				Part Number: D2572	
Inspection Dwg: D2572 Rev. E				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
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B	1.745	1.755		1.745	1.748	1.745	1.745		
C	3.495	3.505		3.497	3.498	3.497	3.498		
D	1.745	1.755		1.745	1.748	1.745	1.745		
E	7.990	8.010		7.999	8.001	8.006	7.999		
F	0.490	0.510		0.493	0.491	0.496	0.495		
G	0.257	0.262	DT8683	0.259	0.259	0.259	0.259		
H	0.375	0.380	DT8684	0.377	0.374	0.374	0.377		
I	0.490	0.510		0.495	0.497	0.498	0.499		
J	1.174	1.184		1.175	1.175	1.178	1.177		
K	0.558	0.578		0.563	0.565	0.564	0.560		
L	1.174	1.184		1.175	1.175	1.178	1.177		
M	1.490	1.500		1.490	1.494	1.491	1.491		
N	2.495	2.505		2.495	2.497	2.495	2.496		
O	3.869	3.879		3.871	3.872	3.870	3.873		
P	0.115	0.135		0.124	0.124	0.124	0.126		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.251	0.252	0.252	0.249		
S	0.115	0.135		0.123	0.122	0.123	0.123		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.235	0.237	0.239	0.238		
W	0.115	0.135		0.136	0.129	0.131	0.128		
X	0.307	0.312		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.360	0.365	0.362	0.362		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.621	0.622	0.621	0.624		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.245	0.247	0.244	0.244		
AE	1.375	1.395		1.384	1.384	1.384	1.387		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.249	0.246	0.248	0.247		
AI	2.000	2.020		w14	w14	w14	w14		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by:	EP	Audited by:	SD
Date:	06/07/14	Date:	06.07.18

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	SD

DART AEROSPACE LTD

Work Order: 27762

Description: Saddle, Fwd Inboard

Part Number: D2572

Inspection Dwg: D2572 Rev. E

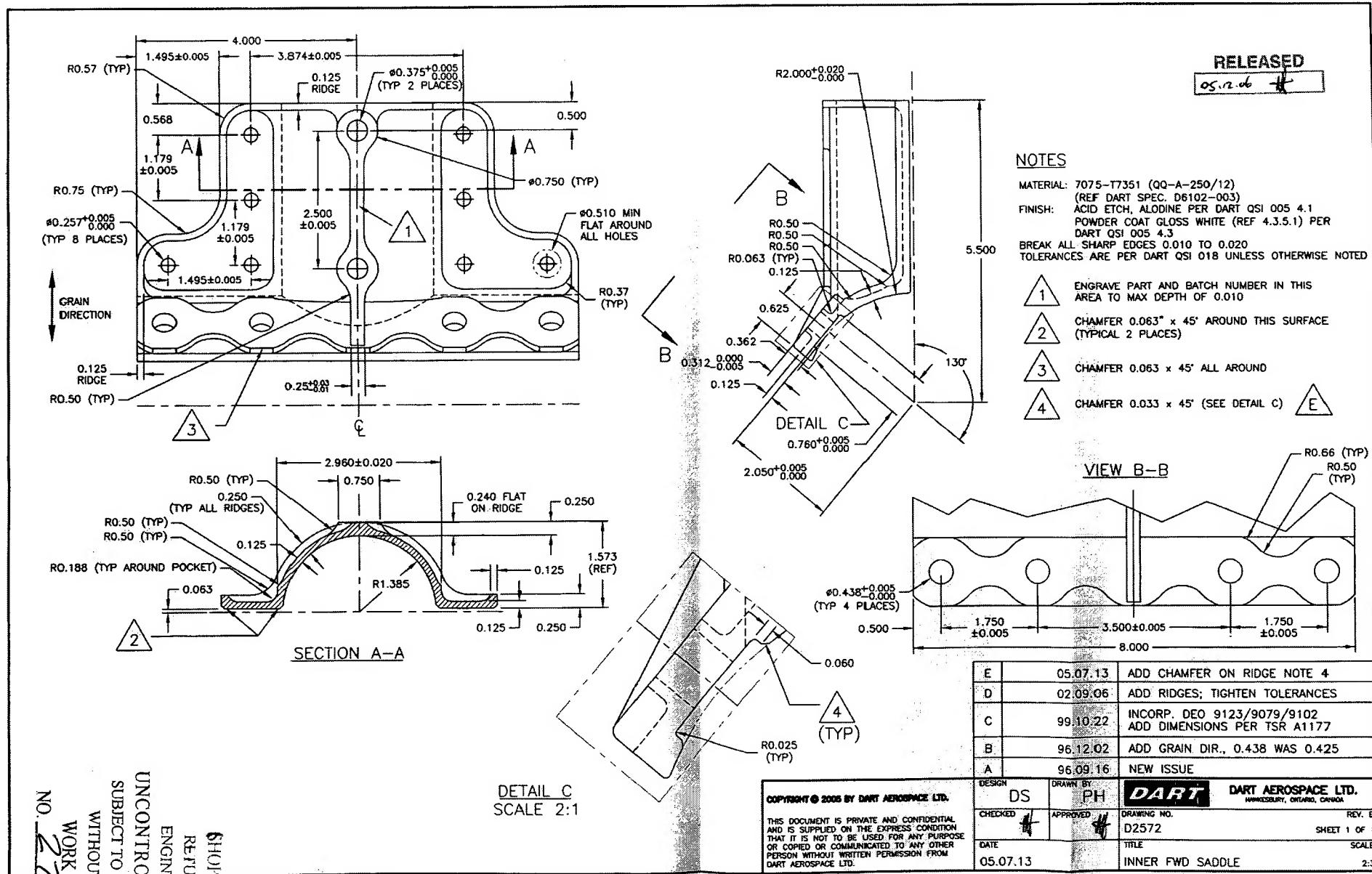
Page 1 of 1

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				1	2	3	4		
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C	3.495	3.505		3.499	3.498	3.497	3.498		
D	1.745	1.755		1.748	1.747	1.746	1.746		
E	7.990	8.010		8.001	8.000	8.001	8.002		
F	0.490	0.510		0.501	0.499	0.498	0.499		
G	0.257	0.262	DT8683	0.259	0.257	0.257	0.257		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.501	0.499	0.498	0.497		
J	1.174	1.184		1.180	1.179	1.180	1.180		
K	0.558	0.578		0.569	0.568	0.567	0.568		
L	1.174	1.184		1.179	1.179	1.180	1.179		
M	1.490	1.500		1.499	1.498	1.497	1.497		
N	2.495	2.505		2.498	2.497	2.496	2.495		
O	3.869	3.879		3.869	3.869	3.869	3.869		
P	0.115	0.135		0.120	0.124	0.123	0.124		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.250	0.248	0.247	0.248		
S	0.115	0.135		0.120	0.124	0.125	0.124		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.236	0.237	0.236	0.237		
W	0.115	0.135		0.124	0.125	0.126	0.125		
X	0.307	0.312		0.316	0.310	0.310	0.310		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.365	0.364	0.363	0.364		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.628	0.624	0.623	0.621		
AC	0.053	0.073		0.063	0.063	0.062	0.063		
AD	0.240	0.260		0.250	0.249	0.247	0.246		
AE	1.375	1.395		1.384	1.384	1.383	1.384		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.251	0.249	0.248	0.247		
AI	2.000	2.020		n/a	n/a	n/a	n/a		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by: J.S /
Date: 06/07/18Audited by: SA
Date: 06.07.18

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
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D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	SA



SHOJ COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 27762

Chris Provencal

From: David Shepherd [dshepherd@dartaero.com]
Sent: July 10, 2006 2:25 PM
To: 'Chris Provencal'
Subject: RE: NCR 205 Saddles

I agree. Scrap them.

David

From: Chris Provencal [mailto:cprovencal@dartaero.com]
Sent: Monday, July 10, 2006 11:30 AM
To: David Shepherd (David Shepherd)
Cc: 'Serge Shahbazian'
Subject: NCR 205 Saddles

David:

D2572 Saddle, the saddle-to-skidtube holes are offset 0.016" to one side.

D2571 Saddle, the saddle-to-skidtube holes are offset 0.025" to one side.

I would be tempted to scrap them, at least the 0.025" one because I know how hard it is already to assembly the bushings into the saddles and have everything line up.

-Chris

